

**Work Order ID 70559**

Friday, June 10, 2011 3:43:41 PM



Page 1

Item ID: D2583

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Bracket

Start Date: 6/10/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

*M*Date: *6-10-13*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2583

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 ☐ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-  
Deburr if necessary*5052 . 410**B11-6-13**(40)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B11-6-13*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*m 11 06 13 (40)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Item Name: Latch Bracket

Start Date: 6/10/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: 17

0.00



Packaging

Memo

0.00

Packaging

24 40X M/L 11/06/17

40 φ PK 11-6-17.

11/6/20 40 S

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 70559**

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Accept

Setup Start

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Item Name: Latch Bracket

Start Date: 6/10/2011 Start Qty: 24.00

Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 24.00

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/21  
MF  
11-06-21

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

Friday, June 10, 2011 3:43:47 PM

Page 1

Work Order ID: 70559



Parent Item: D2583

Parent Item Name: Latch Bracket

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat- in house process DM  
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	48.3000	0.1169	2.953263			

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT022

48.3

117130

48.3

B11-6-13

117130

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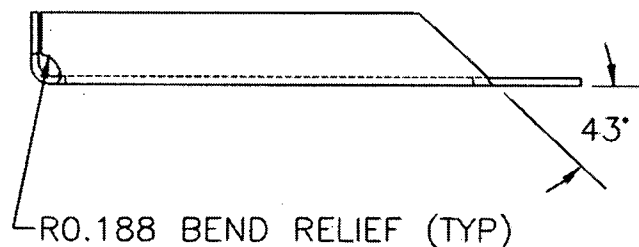
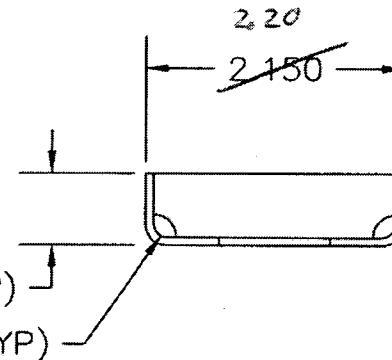
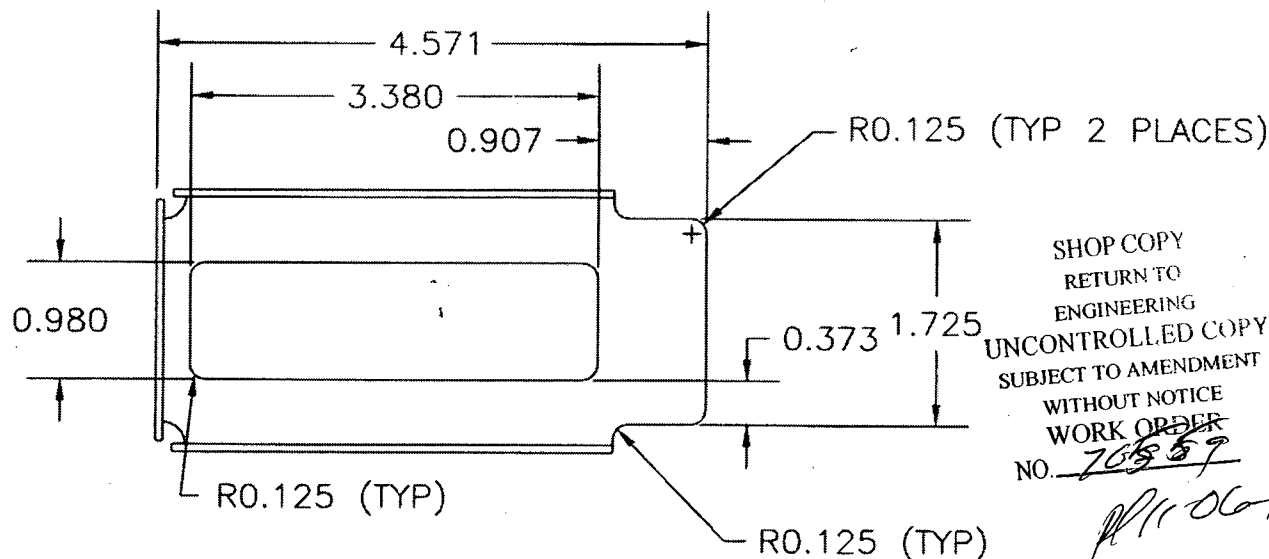
RELEASED  
KE 99.02.25

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70559

*11/06/12*

KE 99.02.26

DESIGN	MIKE M.	DRAWN BY	DART AEROSPACE LTD
CHECKED	<i>CP</i>	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.22	DRAWING NO.	D2583
		TITLE	LATCH BRACKET
		SCALE	2:3
		REV. B	
		SHEET 1 OF 1	
		DATE	99.02.22
		CHANGE OF FINISH (PER TSR A887)	
		NEW ISSUE	
		96.07.10	
		99.02.22	



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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